



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3205-3

Job Sheet 193504



Part No: D3205-3

Job Qty: 6 pcs

Part Name: Back Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/16/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP B 05.01.31 Revised Step 10 KJ/JLM IPP REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

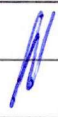
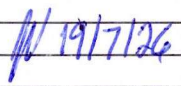
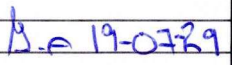
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	6 pcs		4/26/19	0.12	0.61	Waterjet - Flow		JRB 5/22/19
120	QC 2	6 pcs		4/26/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		04/05/19
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
125 Conventional Mill - 1 - B4B	6 pcs	4/26/19	0.00	0.62	Conventional Mill - 1 - B4B	
					Conventional Mill - 2 - B4B	
127 QC 2	6 pcs	4/26/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
130 QC 8	6 pcs	4/26/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	

					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
140	Handfinish - 1-1 Chemical-B4B	6 pcs	4/26/19	0.00 0.18	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	610Z 0 E T0C
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
145	QC 7	6 pcs	4/26/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	BL 19-8-1
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
150	Powdercoat - 3 Grey Sand - B4B	6 pcs	4/26/19	0.00 0.10	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BL 19-8-1
					Powdercoat - 4 - B4B	
160	QC 3	6 pcs	4/26/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	

				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				170 Packaging 3-1 - Stock - B4B	6 pcs
Packaging 3 - 2 - B4B					
Packaging 3 - 3 - B4B					
Packaging 3 - 4 - B4B					
Packaging 3 - 5 - B4B	DAS				
Packaging 3 - 6 - B4B	28				
Packaging 3 - 7 - B4B	9-89				
Packaging 3 - 8 - B4B					
Packaging 3 - 9 - B4B					
Packaging 3 - 10 - B4B					
Packaging 3 - 11 - B4B					
Packaging 3 - 12 - B4B					
Packaging 3 - 13 - B4B					
Packaging 3 - 14 - B4B					
Packaging 3 - 15 - B4B					
Packaging 3 - 16 - B4B					
Packaging 3 - 17 - B4B					
Packaging 3 - 18 - B4B					
Packaging 3 - 19 - B4B					
Packaging 3 - 20 - B4B					
Packaging 3 - 21 - B4B					
Packaging 3 - 22 - B4B					
Packaging 3 - 23 - B4B					
Packaging 3 - 24 - B4B					
Packaging 3 - 25 - B4B					
Packaging 3 - 26 - B4B					
Packaging 3 - 27 - B4B					
Packaging 3 - 28 - B4B					
Packaging 3 - 29 - B4B					
Packaging 3 - 30 - B4B					
Packaging 3 - 31 - B4B					
Packaging 3 - 32 - B4B					
Packaging 3 - 33 - B4B					
Packaging 3 - 34 - B4B					
Packaging 3 - 35 - B4B					
Packaging 3 - 36 - B4B					
180 QC 21 - SA	6 pcs	4/26/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - CUT AS PER DWG DWG REV: _____

Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)

125 - (Manufacture as per dwg) MILL CHAMFER

127 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

DAS

AUG 07 2019

140 - (Chemical Conversion Coat per QSI005 4.1)
 145 - (QC7-Inspect Chemical Conversion Coat)
 150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____) LOCATION : GA
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.250	6061T6 Sheet .250	.1800 sf (.03 ea)	100-Waterjet - Flow - 1	SL38977

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.250	0	86	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Back Plate	0.250Inches $\pm$ 0.010	0.260 0.240	2,254	
2	Back Plate	0.500Inches $\pm$ 0.005	0.505 0.495	0,500	
3	Back Plate	2.380Inches $\pm$ 0.010	2.390 2.370	2,386	
4	Back Plate	1.380Inches $\pm$ 0.005	1.385 1.375	1,378	
5	Back Plate	0.250Inches $\pm$ 0.030	0.280 0.220	0,250	Radius
6	Back Plate	0.130Inches $\pm$ 0.030	0.160 0.100	0,130	Radius
7	Back Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0,258	Diameter
8	Back Plate	0.440Inches $\pm$ 0.005	0.445 0.435	0,438	
9	Back Plate	1.750Inches $\pm$ 0.010	1.760 1.740	1,748	
10	Back Plate	0.100Inches $\pm$ 0.030	0.130 0.070	0,095	
11	Back Plate	45.000Degrees $\pm$ 0.500	45.500 44.500	45°	Angle

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

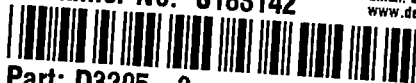
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S183142



Part: D3205-3

Job No: 193504

Serial No/Batch: S183142

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/22/19